

Date: Monday, 23/02/2009 3:30:25 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDER ASSEMBLY
Job Number	: 46026		
Estimate Number	: 13247		
P.O. Number	:	Part Number	: D3695041
This Issue	: 23/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3695 REVC
First Issue	: / /	Project Number	: N/A
Previous Run	: 44878	Drawing Revision	: C
	Type	Material	:
	: MACHINED PARTS	Due Date	: 15/03/2009
Written By	:	Qty:	4 Um: Each
Checked & Approved By	: <u>140 09.02.24</u>		
Comment	: Est Rev:A new issue 08-03-27 DD verified by:ec Est Rev:B 09-01-13 revC prelim as per dwg DD verified by:ec Est Rev:C 09-02-20 rev.c asper dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D36951

Slider



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

SLIDER

batch:

4/60109.k2 441763 x2

88 09/03/18 (x4)

2.0

D36953

Stopper



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

STOPPER

batch:

460110

88 09/03/18 (x4)

3.0

D38011

Hand Retractable Spring Plunger



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Hand Retractable Spring Plunger

batch:

844537

88 09/03/18 (x4)

4.0

MS21209F120

HELI COIL



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) + 4

HELI COIL

batch:

1107853

88 09/03/18 (x4)

5.0

MS21209F625

Heli-Coil



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) + 1

Heli-Coil

batch:

1108138

88 09/03/18 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3695-041 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/04/03
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46026</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05/03/01</u>	<u>7.0</u>	<u>5</u> Reli coil were scrap because when try to installed Reli-coil broke find out add to retap hole before installation R.C process	<u>05/04/02</u>	Tap all hole + put Reli coil after m S21209 F120 <u>5</u> x m107023 m S21209 F625 <u>1</u> x m108130	<u>FF</u> <u>09/03/23</u>	<u>S</u> <u>02/04/02</u>	<u>05/04/02</u>	<u>05/03/01</u>

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:30:25 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDER ASSEMBLY

Job Number: 46026

Part Number: D3695041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS24693C276

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) + 6

Screw

batch: M8170

88 02/03/18 (4)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- install heli-coil as per dwg D3695

2- install D3695-3 and spring plug as per dwg D3695

(P10)

Previous page

FF 09-03-31 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/01 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: 255

9/4/0

(4)

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/02 (4)

Job Completion



MF 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

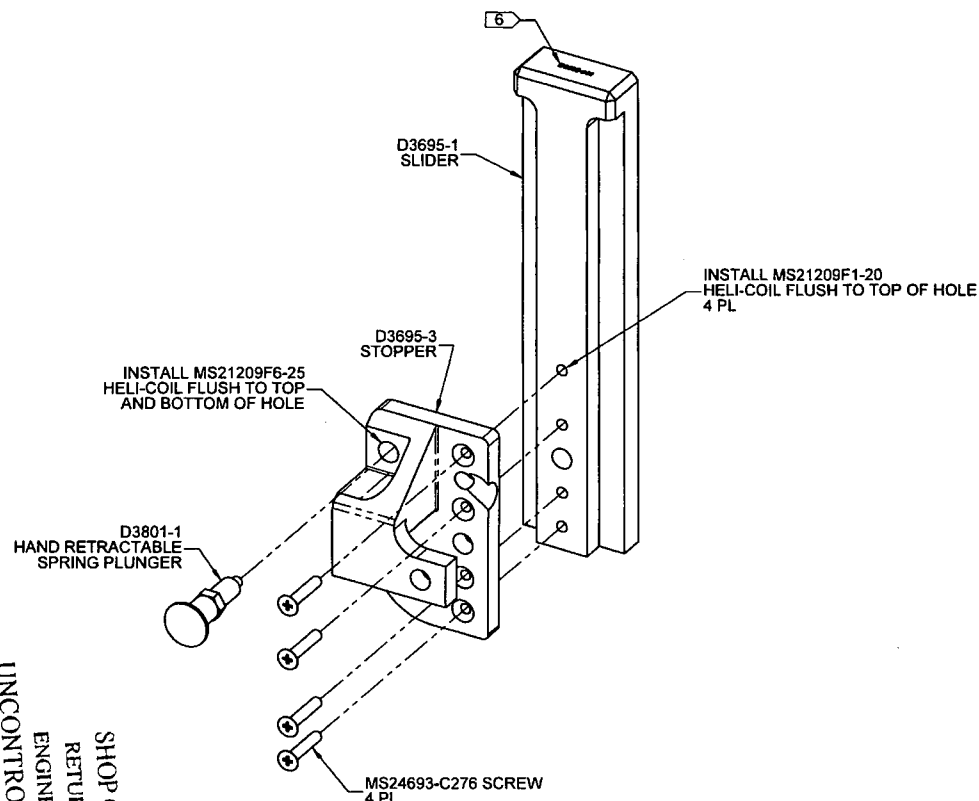
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW



D3695-041 SLIDER ASSEMBLY

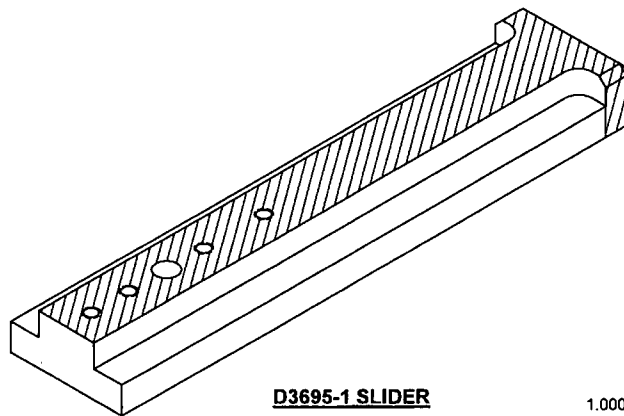
C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{±.002} WERE 1.81 AND 1.063 ^{±.002} (ZN B6-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.09.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	08.11.04		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3695 REV. C SHEET 1 OF 3 TITLE SLIDER ASSEMBLY SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

D3695-041 NOTES:

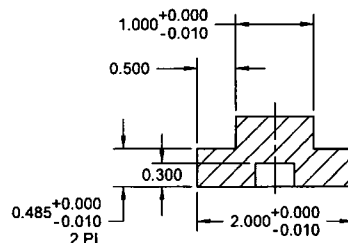
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

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WORK ORDER
NO. 110022

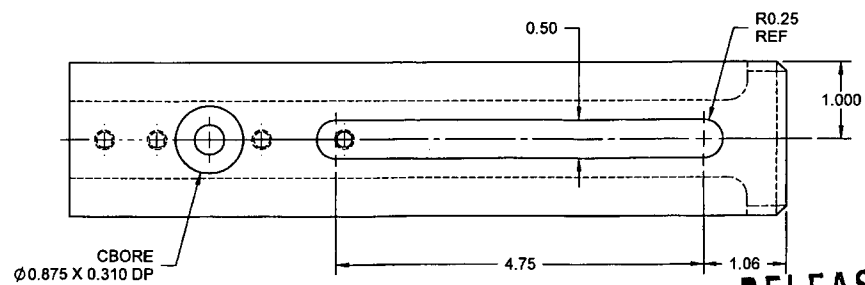
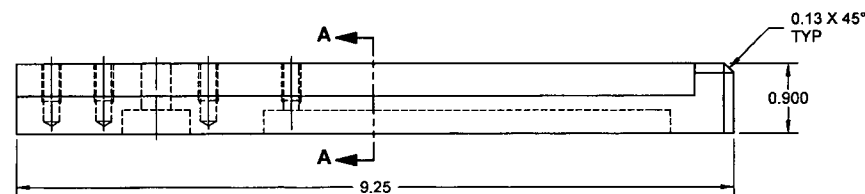
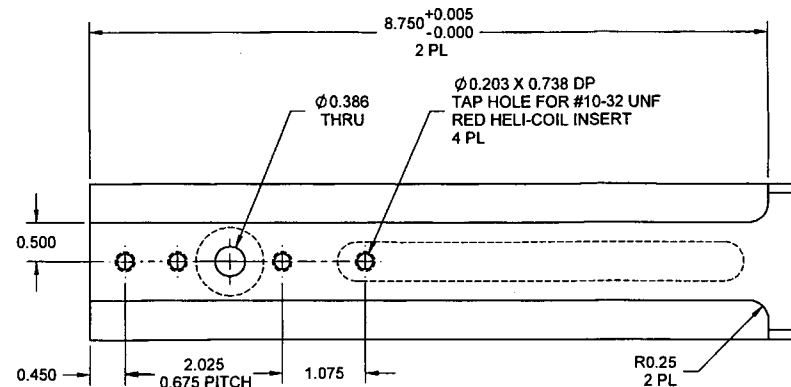
RELEASED
09/02/05 NTP



D3695-1 SLIDER



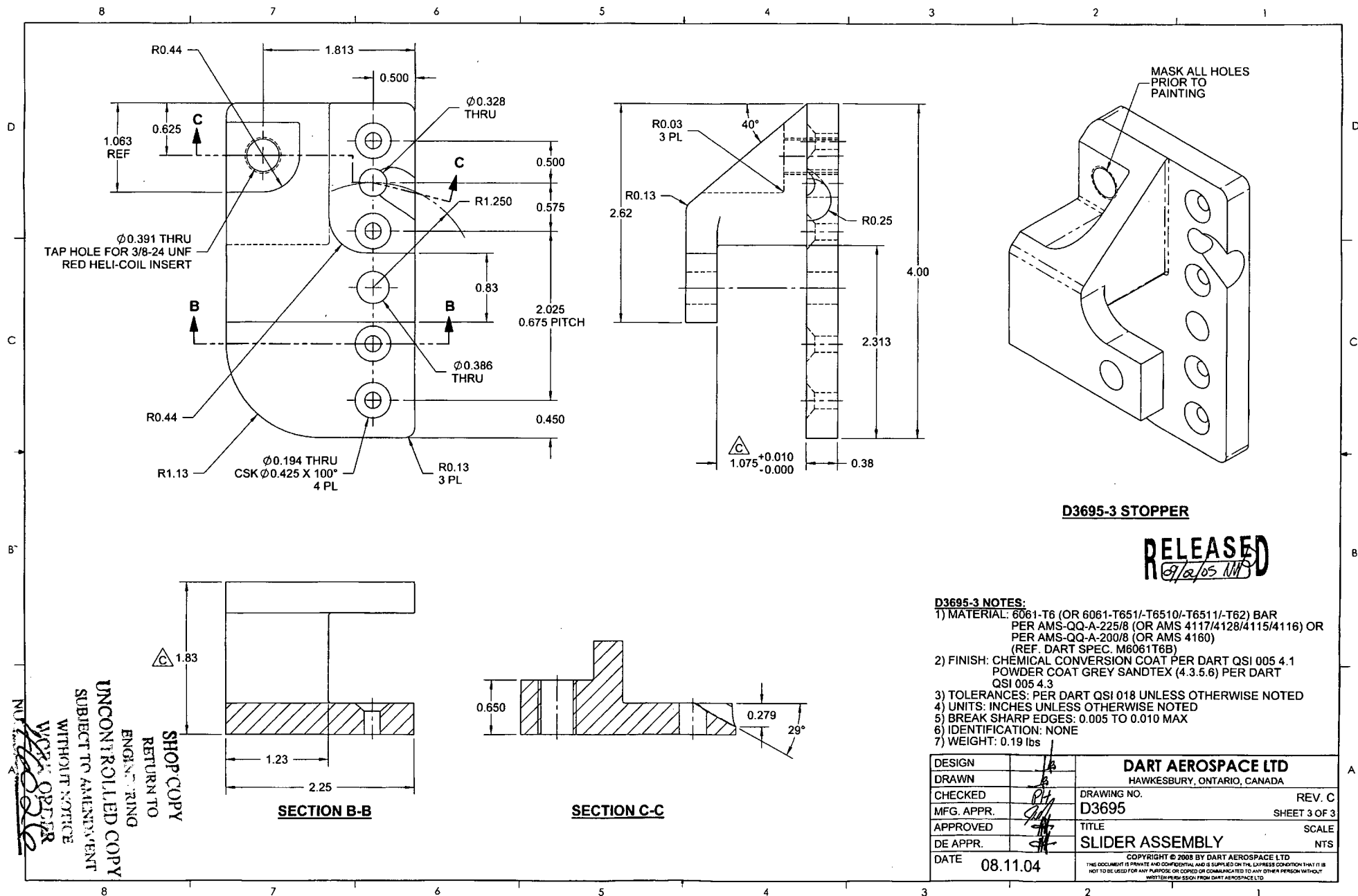
SECTION A-A



RELEASED
08/12/05

- D3695-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T6511/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.43lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3695	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		SLIDER ASSEMBLY	SCALE
DE APPR.			NTS
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D3695-3 STOPPER

RELEASED
8/2/05

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	14	DART AEROSPACE LTD	
DRAWN	14	HAWKESBURY, ONTARIO, CANADA	
CHECKED	14	DRAWING NO.	REV. C
MFG. APPR.	14	D3695	SHEET 3 OF 3
APPROVED	14	TITLE	SCALE
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